

Split



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3235-1

Job Sheet 195608



Part No: D3235-1

Job Qty: 300 pcs

Part Name: Mounting Lug



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/27/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: D3235 REV.A IPP A 04.04.19 New issue KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
110	Purchasing	300 pcs	7/5/19	7/5/19	0.00	0.00	Purchasing - 1			
							Purchasing - 2			
							Purchasing - 3			
120	Packaging 2-1 - Receive - B4B	300 pcs	7/5/19	7/5/19	0.00	0.00	Packaging 2 - 1 - B4B			JUN 04 2019
							Packaging 2 - 2 - B4B			
							Packaging 2 - 3 - B4B			
							Packaging 2 - 5 - B4B			
							Packaging 2 - 4 - B4B			
							Packaging 2 - 6 - B4B			
							Packaging 2 - 7 - B4B			
							Packaging 2 - 8 - B4B			
							Packaging 2 - 9 - B4B			
							Packaging 2 - 10 - B4B			
							Packaging 2 - 11 - B4B			
							Packaging 2 - 12 - B4B			
							Packaging 2 - 13 - B4B			
							Packaging 2 - 14 - B4B			
							Packaging 2 - 15 - B4B			
							Packaging 2 - 16 - B4B			
							Packaging 2 - 17 - B4B			
							Packaging 2 - 18 - B4B			
							Packaging 2 - 19 - B4B			
							Packaging 2 - 20 - B4B			
							Packaging 2 - 21 - B4B			
							Packaging 2 - 22 - B4B			
							Packaging 2 - 23 - B4B			
							Packaging 2 - 24 - B4B			
							Packaging 2 - 25 - B4B			
							Packaging 2 - 26 - B4B			
							Packaging 2 - 27 - B4B			
							Packaging 2 - 28 - B4B			



Container No: S187397



Part: D3235 - 1
Job No: 195608
Serial No/Batch: S187397

Revision: A
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/04/19



Dart Aerospace Ltd.
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Container No: S187397



Part: D3235-1

Job No: 195608

Serial No/Batch: S187397

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 06/04/19

				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
130	QC 6	300 pcs	7/5/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
140	Handfinish - 1-1 Chemical-B4B	300 pcs	7/5/19	0.00 2.40	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	QC 3	300 pcs	7/5/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28

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JUN 20 2019 9-89

BEB 19-06-22.

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9-89

					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
160 Powdercoat - 1 White Gl(A)- B4B	300 pcs	7/5/19	0.00 2.84	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		BEB 19-06-24
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
170 QC 3	300 pcs	7/5/19	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		JUN 25 2019 40
				QC 3 - 19		9-89
				QC 3 - 43		
				QC 3 - 24		
180 Packaging 3-1 - Stock - B4B	300 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B		
				Packaging 3 - 2 - B4B		
				Packaging 3 - 3 - B4B		
				Packaging 3 - 4 - B4B	57522	DAS 74 JUN 27 2019
				Packaging 3 - 5 - B4B		9-89
				Packaging 3 - 6 - B4B		
				Packaging 3 - 7 - B4B		
				Packaging 3 - 8 - B4B		
				Packaging 3 - 9 - B4B		
				Packaging 3 - 10 - B4B		
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					Packaging 3 - 21 - B4B	
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					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	300	7/5/19	0.00 0.00	QC 21 - SA - 21		DAS
	pcs			QC 21 - SA - 70	JUN 28 2019	77
				QC 21 - SA - 53		9-89

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Part Op 110 - (Purchasing) Issue P/O to Metec : HB043578 Machine as per dwg C of C is required
 Descriptions: 120 - (Receive & Inspect for Damage & Mat'l Certs) Ensure C of C is attach

130 - (QC6- All purchased or subcontracted products)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC3- Inspect Part Finish)

160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: 2:10 OVEN TEMPERATURE: 320°FINISH TIME: 2:40 5775459

170 - (QC3- Inspect Part Finish)

180 - (Identify as per dwg & Stock Location: _____)

190 - QC21- Final Inspection - Work Order Release)

x 30, plus Mai 29, 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423	Lug Extrusion	20.4900 ft (.0683 ea) for 30lx	110-Purchasing	300x = 20.4900
D3235-1P	Lug	300 pcs (1 ea)	110-Purchasing	1x = 0.06835F
				5137380

5141186
5101247

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Purchasing	D2423	20	249	0
	D3235-1P	300	0	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Mounting Log	4.450inches $\pm$ 0.010	4.460 4.440		
2	Mounting Log	0.306inches $\pm$ 0.010	0.316 0.296		
3	Mounting Log	1.850inches $\pm$ 0.030	1.880 1.820		
4	Mounting Log	1.200inches $\pm$ 0.010	1.210 1.190		
5	Mounting Log	0.125inches $\pm$ 0.010	0.135 0.115		
6	Mounting Log	0.400inches $\pm$ 0.010	0.410 0.390		
7	Mounting Log	0.735inches $\pm$ 0.030	0.765 0.705		
8	Mounting Log	0.505inches + 0.005 - 0.000	0.510 0.505		
9	Mounting Log	0.380inches $\pm$ 0.030	0.410 0.350		
10	Mounting Log	3.700inches $\pm$ 0.005	3.705 3.695		
11	Mounting Log	0.375inches $\pm$ 0.010	0.385 0.365		
12	Mounting Log	0.750inches $\pm$ 0.010	0.760 0.740		
13	Mounting Log	0.257inches + 0.005 - 0.000	0.262 0.257		
14	Mounting Log	0.380inches $\pm$ 0.030	0.410 0.350		

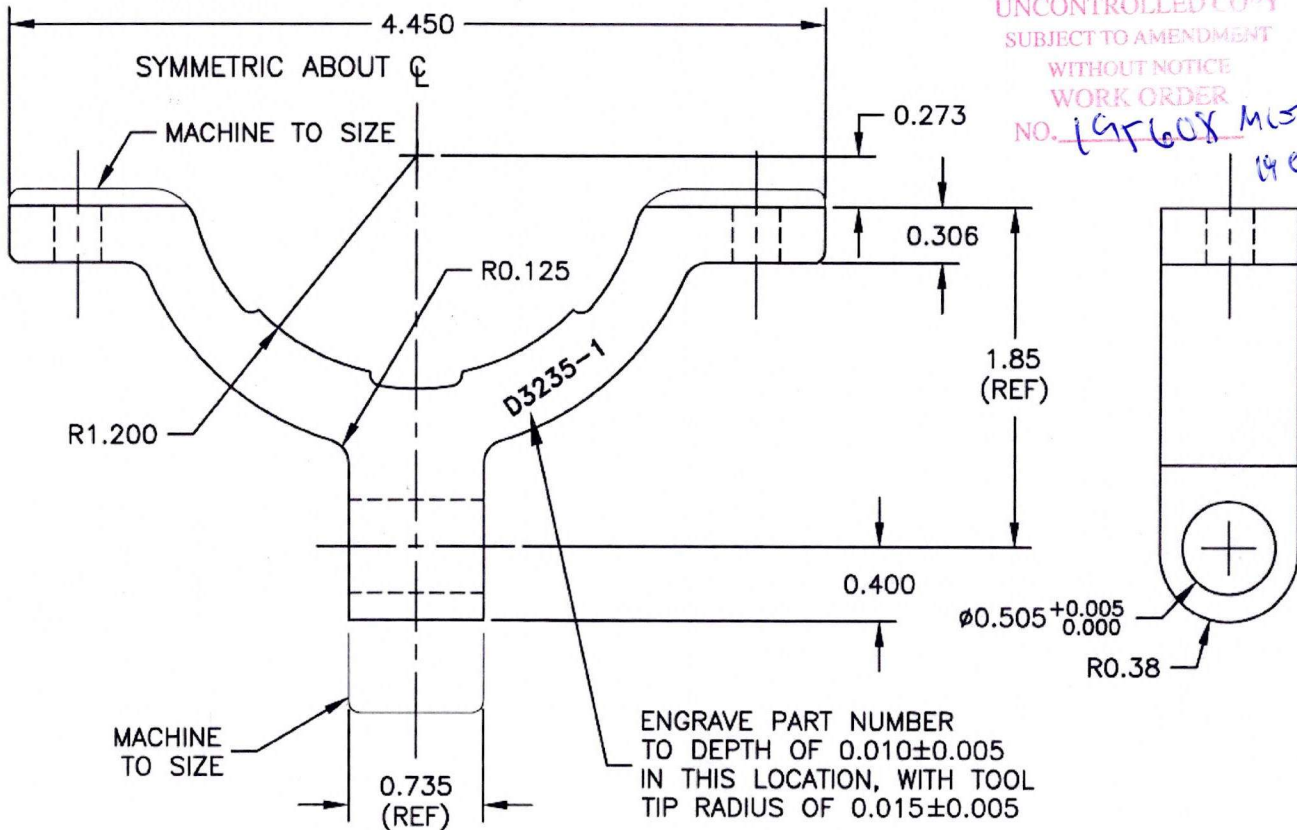
Plex 5/27/19 1:06 PM Dart.lajeunesse.marie

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED
04.04.05 [Signature]

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 195608 M15
1405-24

**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043578



Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043578

PO Date: 5/29/19

Due Date: 7/26/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	195597	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	6/14/19	300 pcs	0 pcs	300 pcs	\$14.90/pcs	\$4,470.00
2	195598	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	7/5/19	100 pcs	0 pcs	100 pcs	\$14.90/pcs	\$1,490.00
3	195599	D2230-3P			Lug As Per Dwg D2230 Rev. G Alodine and Paint as per QSI005	Firmed	-	7/26/19	400 pcs	0 pcs	400 pcs	\$14.90/pcs	\$5,960.00
4	195608	D3235-1P			Lug : Various STC's As Per Dwg D3235 Rev. A Alodine and Paint as per QS I005	Firmed	-	7/5/19	301 pcs	0 pcs	301 pcs	\$16.20/pcs	\$4,876.20
5	195606	D3338-1P			Mounting Lug : Various STC's receive pcs	Firmed	-	7/15/19	40 pcs	0 pcs	40 pcs	\$22.25/pcs	\$890.00

Grand Total: \$17,686.20

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
POHB043578



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "Patrick Lussier", written over the bottom right of the Order Notes section.

Plex 6/4/19 11:02 AM dart.Lussier.Patrick

**METAL TECHNOLOGY INC.****www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956**

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Shipment No: 25349
Shipment Date: 31-May-2019
Ship Via: Pick up at METEC
Order Number: 3894
Order Date: 05/29/19

Customer Code: DART
Phone: (613) 632-9577
PO Number: POHB043578
Terms: Net 60 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	300	300	0	0	EA	D2230-3P Mounting Lug alodined and painted as per QSI005	G	3894-01
4	301	301	0	0	EA	D3235-1P Mounting Lug alodined and painted as per QSI 005	A	3894-04
5	40	40	0	0	EA	D3338-1P Mounting Lug alodined and painted as per QSI005	A	3894-05

RECEIVED
JUN 04 2019
DART AEROSPACE LTD.

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Dart Aerospace Ltd.



METAL TECHNOLOGY INC.

20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
300	D2230-1	Mounting Lug	G	S141186	018475-1	HB043578
40	D3338-1	Mounting Lug	A	S141186	018284-1	HB043578
299	D3235-1	Mounting Lug	A	S141186	017184-1	HB043578
1	D3235-1	Mounting Lug	A	S141186	017018-2	HB043578
1	D3235-1	Mounting Lug	A	S101247	015858-2	HB043578

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MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, May 31, 2019